

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010514**Date Inspected:** 01-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck Panel**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 9

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) on VT repair areas of closed rib Partial Joint Penetration (PJP) welds on deck panels designated as DP 3002A-001. Welder is identified as 059443. ZPMC QC is identified as Chen Shi Gang. In process FCAW appears to be progressing in compliance with WPS 345-FCAW-2G (2F) Repair-1.

North Lay down yard

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) on VT repair areas of closed rib Partial Joint Penetration (PJP) welds on deck panels designated as DP 3006A-001 and DP 3008A-001. Welder is identified as 059409. ZPMC QC is identified as Duan Ya Bing. In process FCAW appears to be progressing in compliance with WPS 345-FCAW-2G (2F) Repair-1.

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation

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numbers is as follows:

DP 3040A-001- 001~006

DP 3041A-001- 001~008

DP 3046A-001- 001~010

QA Inspector performed Final Visual Inspection following the guide lines of AWS-D1.5 on Deck Panel assemblies including Partial Penetration (PJP) welds joining U-ribs to deck plate. The deck panels examined are as follows:

DP 3040A-001: Final VT appears to comply with code and contract requirements.

DP 3041A-001: Final VT appears to comply with code and contract requirements.

DP 3046A-001: Final VT appears to comply with code and contract requirements.

QA Inspector performed Green Tagging activities following the green tagging procedure. The deck panels green tagged are as follows:

DP 3040A-001: Green Tag Number 9521

DP 3041A-001: Green Tag Number 9519

DP 3046A-001: Green Tag Number 9520

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
